

Work Order ID 63330

Wednesday, October 27, 2010 3:50:35 PM



Page 1

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate Assembly

Stop



Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-10-28 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

Draw Nbr	Revision Nbr
D4154	A

100



Large Fab

Memo

0.00

EL 10-11-4 XY

Large Fab

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154
 2059 B Hardcoat Welding Rod
 BATCH#: M15879.

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154
 304 S.S. Welding Rod
 BATCH #: M10174.

3-Transfer drill holes in bar
 4- (AT9684) use to check for fit.

110



QC

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Quality Control

Memo

0.00

PL 10-10-05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

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Tool #

Plan
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QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/11/05

0.00

test fits on slides Fit
not great but will work

130



Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

M 11/25/88

0.00

Memo

START TIME: 10:15
OVEN TEMPERATURE: 320°
FINISH TIME: 10:45.

H 11/25/88

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> H 10/11/05

0.00

Memo

4

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Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Small Fab

Memo

0.00

M 10 11 05 ④

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

use ROCK GUARD-BEIGE

NP 10/11/51

160



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

S iduloe

(44) _____

Quality Control

170



Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

D 10 11 08 ⑨

Packaging

W/O:		WORK ORDER CHANGES					
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Customer:

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Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Picklist Print

Wednesday, October 27, 2010 3:50:39 PM

Page 1

Work Order ID: 63330



Parent Item: D4154-041



Parent Item Name: Wearplate Assembly

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1 		Manufactured	No Plate			100	Each	1.0000	1	4	 EL 10-11-4.		
							<u>Location</u>	<u>Loc Qty</u>					
					WA			1					
						62199		1					
D4155-1 		Manufactured	No Bar			100	Each	2.0000	1	4	 EL 10-11-4.		
							<u>Location</u>	<u>Loc Qty</u>					
					ST			2					
						60976		2					

B 63331 x4

B 62331 x4

W/O:		WORK ORDER CHANGES					
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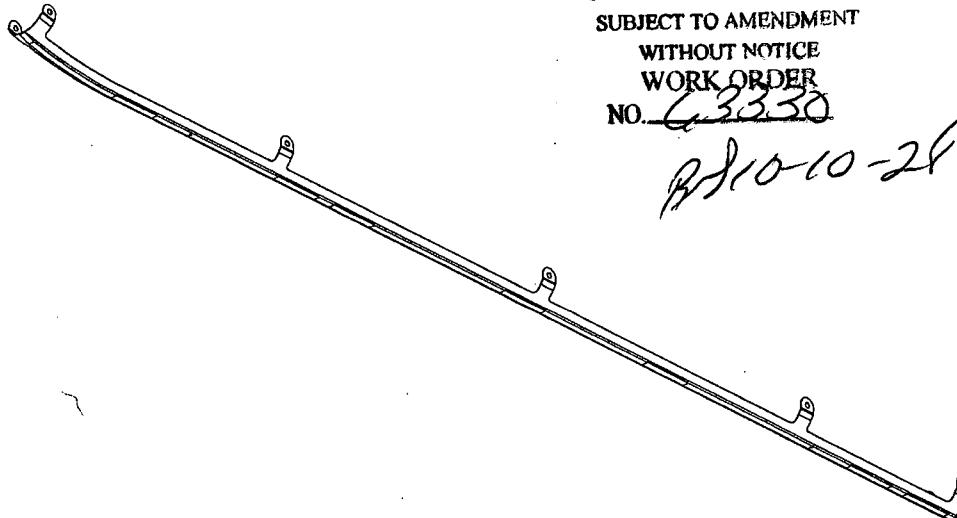
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8 7 6 5 4 3 2 1

D

D



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63330

28/09/2010-26

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

C

C

B

B

D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010-09-15
M

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>PP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MM</i>	D4154	SHEET 1 OF 3
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS EXCLUDED FROM TRADE SECRET STATUS. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

A

1

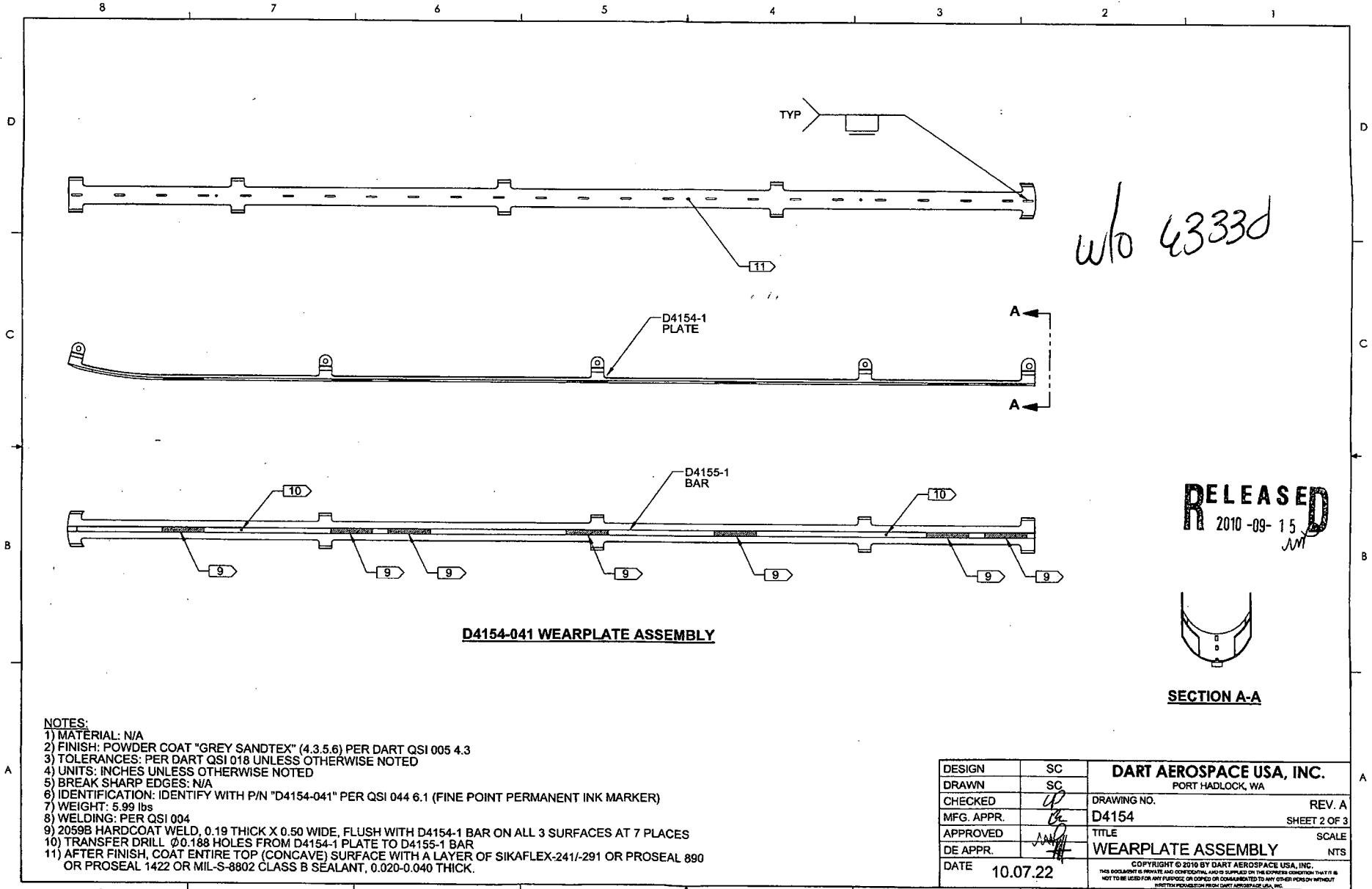
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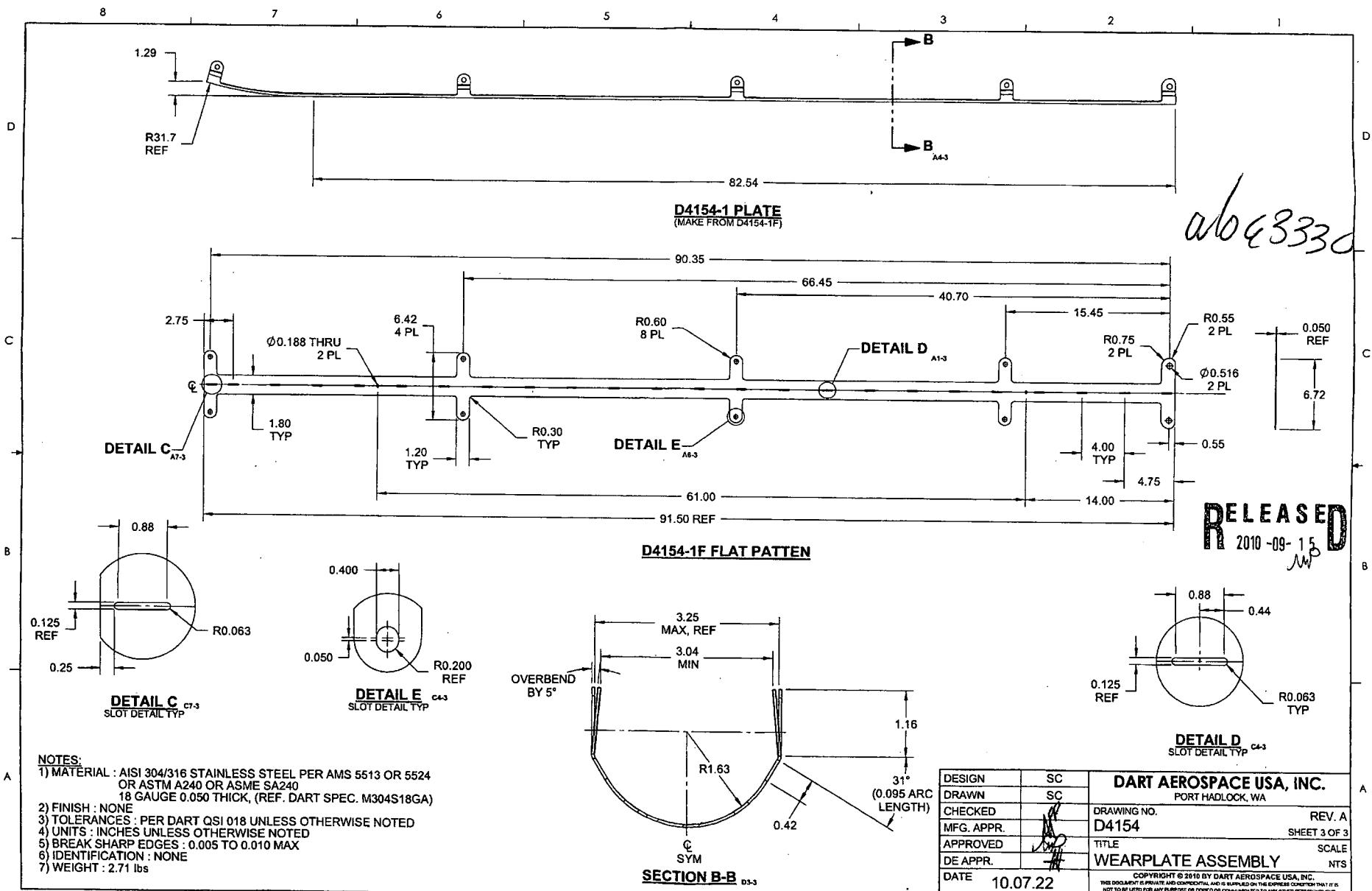
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